

S-7016.HR

Type : Basic

Conformances

AWS A5.1/ ASME SFA5.1 E7016 H4R

JIS Z3211 E4916 H5

EN ISO 2560-A-E42 3 B 1 2 H5

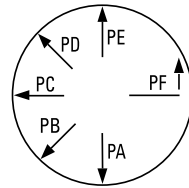
Applications

- Heavy steel fabrication
- Shipbuilding
- Pressure vessels

Features

- Extra low hydrogen electrode
- Good mechanical properties
- Vacuum sealed package available (HDM ≤ 4ml/100g)

Welding Position



Current

AC or DC +

Redrying Conditions

350~400°C (662~752°F) X

0.5~1hr

Diameter / Packaging

Diameter	Length	Standard		Vacuum				P.V.C	
		packet	carton	packet	carton	packet	carton	packet	carton
mm (in)	mm (in)	5kg(11lbs)	20kg(44lbs)	1.5kg(3.3lbs)	15kg(3.3lbs)	5kg(11lbs)	20kg(44lbs)	5kg(11lbs)	20kg(44lbs)
2.6 (3/32)	350 (14)		√		√		√		√
3.2 (1/8)	350 (14)		√		√		√		√
4.0 (5/32)	400 (16)		√		√		√		√
5.0 (3/16)	400 (16)		√		√		√		√

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.064	0.56	1.00	0.012	0.005

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft·lbs)
493 (71,500)	561 (81,400)	30.4	-30 (-22)	173 (128)

Typical Welding Parameters / Amp.(A)

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	350 (14)	350 (14)	400 (16) 450 (18)	400 (16) 450 (18)
F &HF	50-95	90-140	130-180	180-240
V-up, OH	50-95	90-130	120-160	150-200

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX